

Date: Monday, 11/6/2006 2:40:30 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEM
<b>Job Number</b> : 29353A	
<b>Estimate Number</b> : 10399	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D29683
<b>This Issue</b> : 11/6/2006	<b>Drawing Number</b> : D2968
<b>S.O. No.</b> : N/A	<b>Project Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Drawing Revision</b> : B1
<b>First Issue</b> : N/A	<b>Material</b> : N/A
<b>Type</b> : MACHINED PARTS	<b>Due Date</b> : 11/30/2006
<b>Previous Run</b> : 28865A	<b>Qty:</b> 30 <b>Um:</b> Each
<b>Written By</b> : <u>[Signature]</u>	
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	
<b>Comment</b> : Est:C 0304.11 Reformat; Incorporated D2968-1/-5 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR0750	4130 steel rod .750"
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**Comment:** Qty.: 0.3762 f(s)/Unit Total : 11.2865 f(s)

Material: AISI 4130 Ø 3/4 " Bar

(M4130N-R0.750)

Batch: M100559

Identify AS D2968-3

30 df 06/11/30

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn Blank as per Folio FA048 and Dwg D2968

2-Deburr, no sharp edges

30 df 06/11/30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

30 df 06.17.04

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA048 and Dwg D2968

2- Deburr

30 df 06/12/05

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

30 df 06/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LB Date: 06/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:40:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 29353A

Part Number: D29683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/12/05 x 30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/12/07 (30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/06

Job Completion



06-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

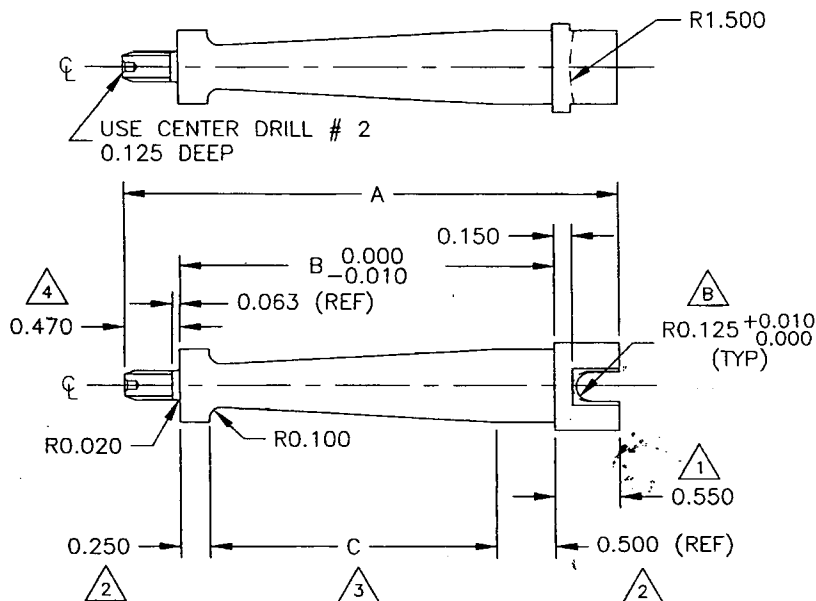
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

**D2968-1 AND D2968-3 STEM:**

MATERIAL: AISI 4130

△ Ø0.750 O.D.

△ Ø0.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø0.363 O.D. TO Ø0.625 O.D.

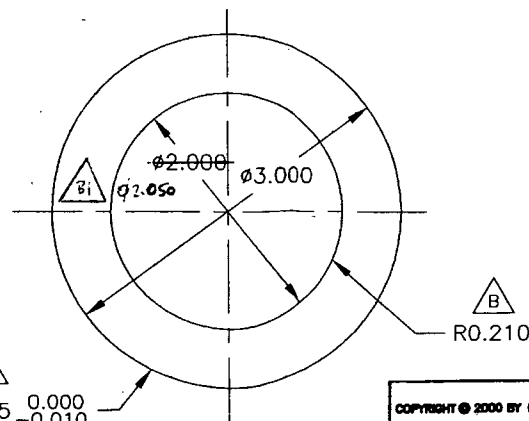
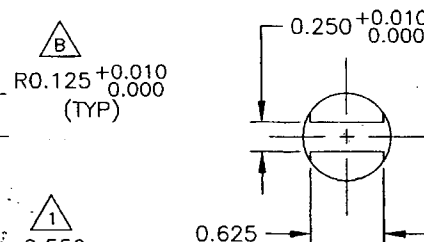
△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2968-5 RING:**

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

RELEASED

UNDER REVIEW

USE 2968-1 STEM FOR -041  
USE 2968-3 STEM FOR -043

**D2968-041 AND D2968-043 TOW RING:**

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING  
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI  
FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	<b>DART</b> DART AEROSPACE LTD. WARRICKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	00.05.31	TOW RING

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WORK ORDER  
29353A  
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